



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2939-2BL
Job Sheet 167811



Part No: D2939-2BL

Job Qty: 10 ea

Part Name: Saddle RH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Revc.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Machining		FK 17-12-8
100	CNC Vertical Machining	10 pcs	11/23/17	11/23/17	0.45	11.00	HAAS 1		SBL 17/12/10
110	Mill Conv	10 pcs	11/23/17	11/23/17	0.00	11.00	Mill Conv 1		SBL 17/12/10
120	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC1		SBL 17/12/10
130	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC8		17-12-11
140	HandFinish	10 pcs	11/23/17	11/23/17	0.00	0.29	HandFinish1		2017-12-12 75L
150	SprayPaint	10 pcs	11/24/17	11/24/17	0.00	0.83	Spray Paint outsource		17-12-17
160	QC	10 pcs	11/24/17	11/24/17	0.00	0.00	QC14		17-12-17
170	Packaging	10 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3	57 392	17-12-17
180	QC21-SA	10 Ea	11/24/17	11/24/17	0.00	0.00	QC21		17-12-17

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - ** MASK ALL HOLES AS PER PAR16-484***

P/O. 38646

DEC 14 2017
13
2-89

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-001	10	29	0	0

Part Specifications

Specifications could not be found.

Plex 11/7/17 8:25 AM dart.Michaud-Febrille.Victoria

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order:		DISPOSITION	AGAINST DEPARTMENT/PROCESS
Part No. _____			
NCR No. _____			
Date : _____			
Descript _____			
		PART NO: D2939 -- 2BL	PART NO: D2939 -- 2BL
		Revision:	Revision:
		Operation:	Operation:
		Change No:	Change No:
		Outsource	Start up Operation
		Saddle RH In, 206	Saddle RH In, 206
		S018989	S018989
		Dart Aerospace Ltd.	Dart Aerospace Ltd.
		1270 Aberdeen Street	1270 Aberdeen Street
		Hawkesbury, ON K64 1K7	Hawkesbury, ON K64 1K7
		CANADA	CANADA
		TEL.: 1 613 632 - 5200	TEL.: 1 613 632 - 5200
		Email: sales@dartaero.com	Email: sales@dartaero.com
		www.dartaerospace.com	www.dartaerospace.com
		Mfg Date: 12/08/17	Mfg Date: 12/08/17
		Job No: 167811	Job No: 167811
		FAU	FAU
		Defect	Defect
		lete/U	lete/U
		incomplete/	incomplete/
		Drill Holes	Drill Holes
		Marks/Chatter	Marks/Chatter
		OTHER :	OTHER :
		Process Improvement	Process Improvement
		Manufacturing Process	Manufacturing Process
		Past Due	Past Due
		Root Cause	Root Cause
		Environment	Environment
		Design	Design
		Doc/Data	Doc/Data
		Equip/Tooling	Equip/Tooling
		Handling/Pre	Handling/Pre
		Material	Material
		Internal Transport	Internal Transport
		Tribal Knowledge	Tribal Knowledge
		LOA	LOA
		Substation	Substation
		Past Expiry Date	Past Expiry Date
		Misidentified	Misidentified
		No Re-ve	No Re-ve
		Operator	Operator
		Offset/St	Offset/St
		Supplier	Supplier
		Training	Training
		Use for T	Use for T
		Poor Info	Poor Info
		Rushing	Rushing
		Product li	Product li
		Process Improvement	Process Improvement
		Manufacturing Process	Manufacturing Process
		Past Due	Past Due

DART AEROSPACE LTD		Work Order: 167 811	
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.117	.119	.118	.117	.117
B	0.100	0.140		.117	.118	.117	.118	.117
C	0.100	0.140		.117	.119	.119	.120	.121
D	0.210	0.230		.226	.227	.226	.226	.226
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.313	.313	.313	.313	.313
M	0.235	0.240		.238	.238	.238	.237	.238
N	0.100	0.140		.119	.121	.121	.121	.121
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.500	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.738	2.738	2.738	2.740
S	0.240	0.270		.255	.255	.256	.255	.256
T	0.100	0.180		.145	.135	.137	.135	.140
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.261	1.262	1.261	1.262	1.261
Y	1.565	1.585		1.576	1.577	1.576	1.577	1.576
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								

Accept/Reject

Measured by: SBL	Date: 17/12/09
Audited by: B.P	Date: 17-12-11
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

DART AEROSPACE LTD		Work Order: 16784
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

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☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.117	.116	.116	.117	.117
B	0.100	0.140		.118	.116	.117	.118	.117
C	0.100	0.140		.122	.120	.120	.120	.119
D	0.210	0.230		.226	.226	.227	.227	.227
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.313	.313	.313	.313	.313
M	0.235	0.240		.238	.238	.238	.238	.238
N	0.100	0.140		.121	.121	.121	.122	.121
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.498	.498	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.737	2.740
S	0.240	0.270		.255	.256	.256	.256	.255
T	0.100	0.180		.134	.135	.136	.140	.138
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.260	1.261	1.261	1.260	1.261
Y	1.565	1.585		1.575	1.575	1.575	1.575	1.576
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								

Accept/Reject

Measured by: SBL	Date: 17/12/09
Audited by: B.E	Date: 17-12-11
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038646

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038646

PO Date: 12/14/17

Due Date: 12/15/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	167807	D2938-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
2	167808	D2938-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
3	167804	D2932-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PAR16-484*** SPRAY PAINT BLEU	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
4	167806	D2933-2BL	Saddle RH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
5	167811	D2939-2BL	Saddle RH In, 206 ** MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
6	167803	D2932-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** BATCH: _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
7	167805	D2933-1BL	Saddle LH In, 206 *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____ ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
8	167810	D2939-1BL	Saddle LH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
9	168325-A	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



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PURCHASE ORDER PO038646

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____							
10	167820-L	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
11	167820-K	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Grand Total:										\$1,675.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/17/18 10:04 AM dart.baker.diane